

Work Order ID 113998

Friday, February 28, 2014 11:26:52 AM

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Item ID: D4482-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Intercoastal 5 Assembly, RH
 Start Date: 2/28/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 3/21/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MR Date: 14-2-28 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4482	C

100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									

110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	1- ASSEMBLE AS PER DWG								

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS

27

9-89

14/6/16

DAS

36

9-89

DAS

36

9-89

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Item ID: D4482-042 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Intercoastal 5 Assembly, RH
Start Date: 2/28/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/21/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>85/05</u>	0.00							
130									
Packaging	Memo	0.00				1x		14-6-9	DAS 26 9-89
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 14-06-10
MF
14-6-9

Picklist Print

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Work Order ID: 113998

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Parent Item: D4482-042

D4482-042

Parent Item Name: Intercoastal 5 Assembly, RH

Start Date: 2/28/2014

Required Date: 3/21/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.12.03 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4482-2		Manufactured	No				Each	3.0000		1			
D4482-2									**			14/06/05	DAS 36 9-89
Intercoastal 5, RH													

Location Loc Qty Loc Code

CA 3
96297 3

D4482-4		Manufactured	No				Each	4.0000		1			
D4482-4									**			14/06/05	DAS 36 9-89
Hinge Plate, RH													

Location Loc Qty Loc Code

CA 4
96301 4

D4488-1		Manufactured	No				Each	15.0000		1			
D4488-1									**			14/06/05	DAS 36 9-89
Clip													

Location Loc Qty Loc Code

CA 15
96098 9
99086 6

MS20426AD3-3		Purchased	No				Each	1,868.000		2			
MS20426AD3-3									**			14/06/05	DAS 36 9-89
RIVET													

Location Loc Qty Loc Code

ST334 1868
123352 1868

M128754 (20)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____

Picklist Print

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Work Order ID: 113998

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Parent Item: D4482-042

D4482-042

Parent Item Name: Intercostal 5 Assembly, RH

Start Date: 2/28/2014

Required Date: 3/21/2014

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-4

Purchased

No

Each

3,322.000

2

MS20426AD4-4

Rivet

14/06/05

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

339

129090

339

ST334

2983

125445

2983

Each

7,074.000

3

MS20426AD3-5

Purchased

No

MS20426AD3-5

Rivet

14/06/05

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

4832

4533

4832

ST334

2242

4444

2242

Each

1,064.000

1

MS21059L08

Purchased

No

MS21059L08

Nut

14/06/05

DAS
36
9-89

Location

Loc Qty

Loc Code

MF4

144

125654

144

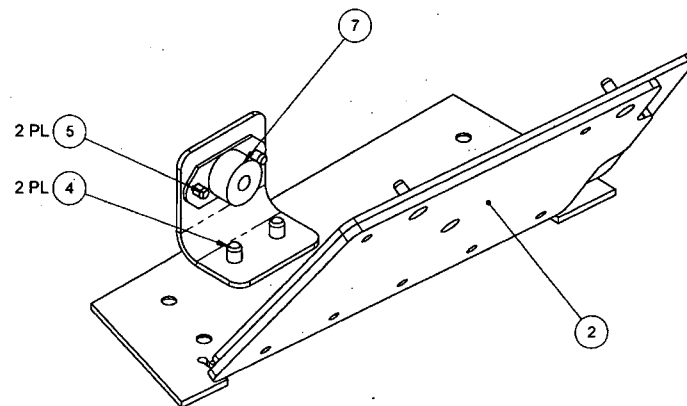
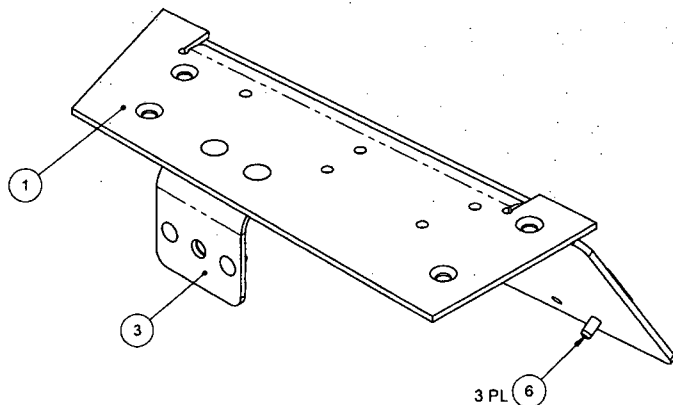
ST508

920

125654

920

ITEM	QTY	P/N	DESCRIPTION
	X	D4482-042	INTERCOSTAL 5 ASSY (RH)
1	1	D4482-2	INTERCOSTAL 5 ASSY (RH)
2	1	D4482-4	HINGE PLATE (RH)
3	1	D4488-1	CLIP
4	2	MS20426AD4-4	RIVET, CSK
5	2	MS20426AD3-3	RIVET, CSK
6	3	MS20426AD3-5	RIVET, CSK
7	1	MS21059L08	NUTPLATE



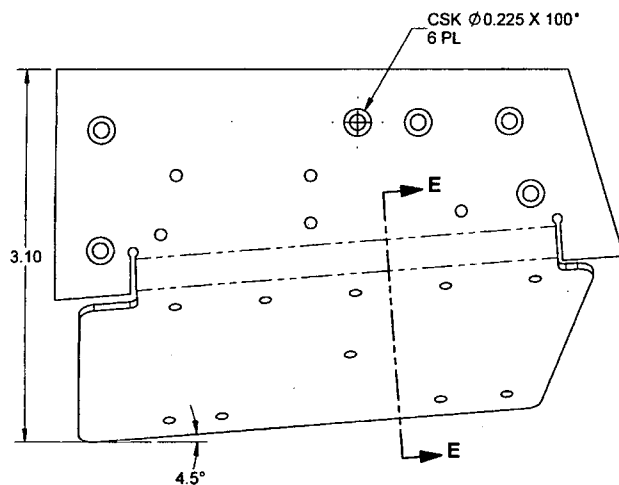
MF
11398
14-2-28

NOTES:

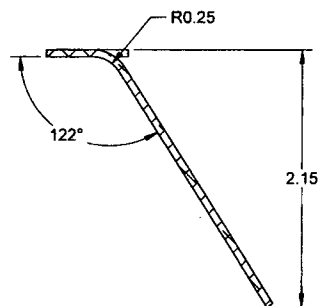
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs

RELEASED
2012-11-29
MD

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JS	DRAWING NO.	REV. C
MFG. APPR.	JS	D4482	SHEET 3 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	INTERCOSTAL 5 ASSY	NTS
DATE	12.10.05	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



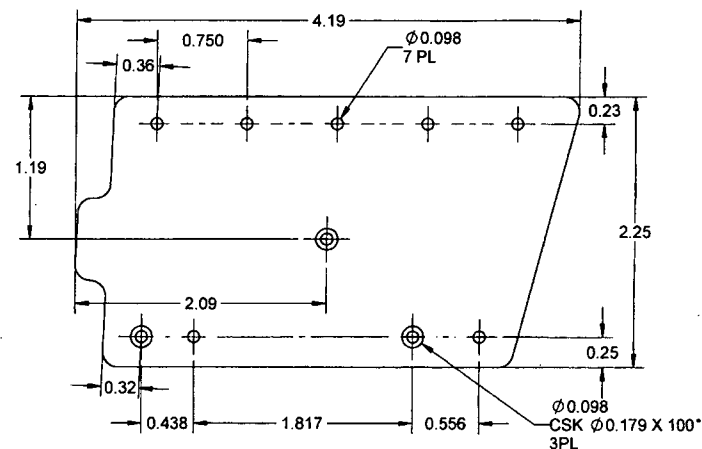
D4482-2 INTERCOSTAL 5 ASSY (RH)



SECTION E-E

NOTES:

- 1) MATERIAL: MAKE FROM D4482-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs



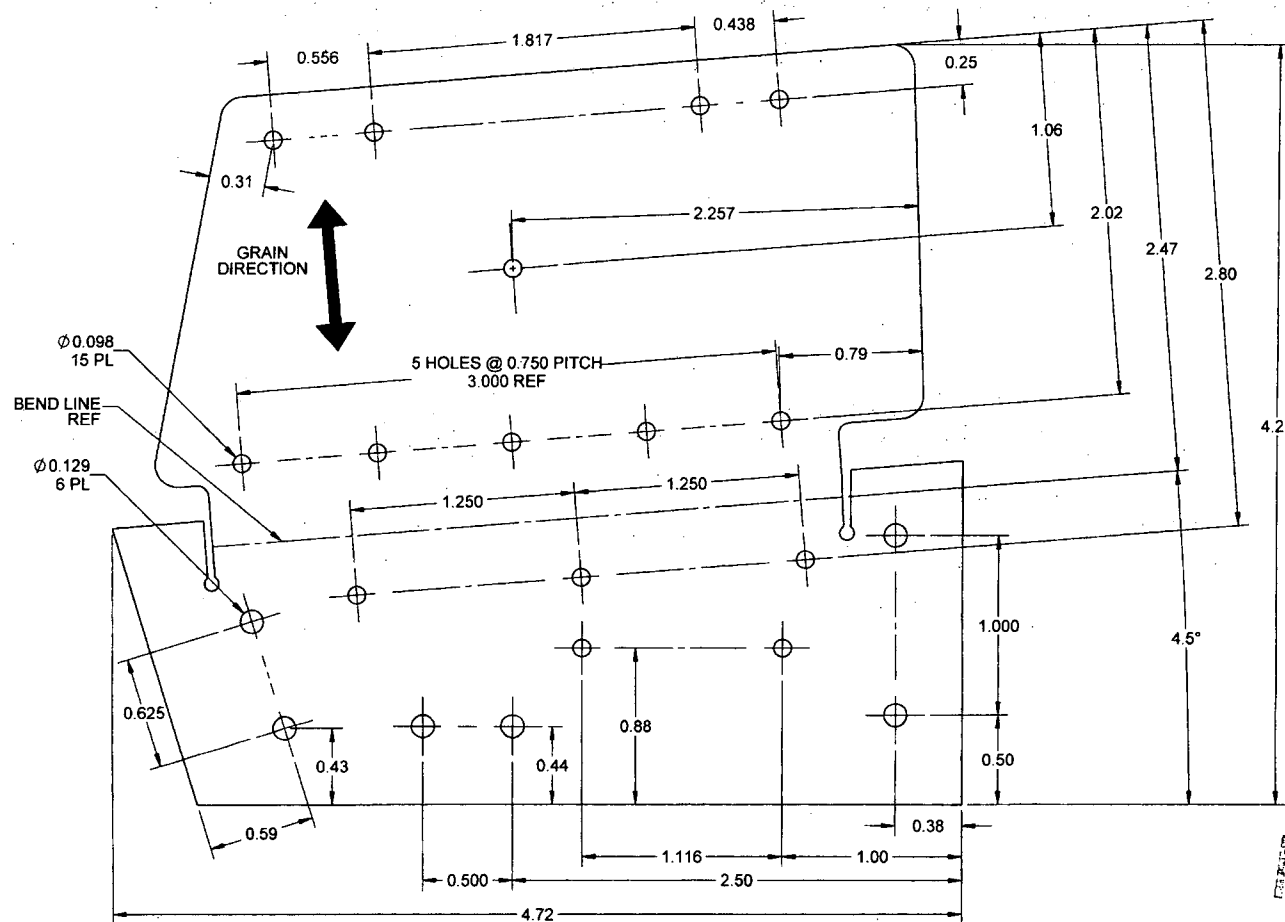
D4482-4 HINGE PLATE (RH)

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.080 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs
- 8) ALL NON DIMENSIONED FEATURES PER DRAWING FILES "D4482-3-REVC.DXF"

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DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4482	REV. C SHEET 4 OF 5
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	INTERCOSTAL 5 ASSY	NTS
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#113998

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D4482-1F INTERCOSTAL 5
(FLAT PATTERN)

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs
- 8) ALL NON DIMENSIONED FEATURES PER DRAWING FILES "D4482-1F-REVC.DXF"

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4482	REV. C SHEET 5 OF 5
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	INTERCOSTAL 5 ASSY	NTS
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